

Date: Monday, 10/16/2006 2:02:59 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SPRING CLIP ASSEMBLY	
Job Number	: 29025		Part Number	: D2429041	
Estimate Number	: 10645		Drawing Number	: D2429 REV C1	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 10/16/2006 S.O. No. : N/A		Drawing Revision	: C1	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 10/30/2006 Qty: 100 Um: Each	
Previous Run	: 27523				
Written By					
Checked & Approved By					
Comment	: Est. D 02/03/06 Added note at step 7 NG Est Rev:E Now on Waterjet 06-06-13 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	304/316 .040 Sheet
		 Comment: Qty.: 0.0071 sf(s)/Unit Total : 0.1428 sf(s) 304/316 .040 Sheet (M304S040) <i>m1012641 Ml 06 12 01</i> Batch: <i>m102159 Ml 06 10 18</i>
2.0	WATER JET	FLOW WATER JET
		 Comment: FLOW WATER JET 1-Cut as per Dwg D2429 Dwg Rev: <i>C1</i> Prog Rev: <i>C1</i>
		<i>Ml 06 12 01</i> (40)
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>Ml 06 12 01</i>
4.0	QC8	SECOND CHECK
		 Comment: SECOND CHECK <i>Jan 10 18 (20) Con't'd. M06/12/01 (20)</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr <i>ml 06/10/05 (20)</i> SB <i>06/12/05 (20)</i> 2-Bend D2429-1 as per Dwg D2429 <i>SB 06/11/05</i>
		<i>SB 06/12/05 (20)</i> 40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/12/05	5.1	Add QCS to step 5.1 Perm. chg.	EE	06.12.05	HO		AA 06/12/05

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/12/05
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/16/2006 2:02:59 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPRING CLIP ASSEMBLY

Job Number: 29025

Part Number: D2429041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 MS20470AD45 Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Rivet, Universal Head

Pick:

Qty	Part number	Description	Batch
1	MS20470AD4-5	Rivet	118491

SB

06/12/06

20

7.0 AN960JD6L Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s)

Washer

Pick:

Qty	Part number	Description	Batch
2	AN960JD6L	Washer	MSS19

SB

06/12/06

20

NOTE: 2 D2429-1 required for 1 assy.

8.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble D2429-041 as per Dwg D2429

SB

06/12/06

20

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/12/06

20

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST45

06/12/06

20

11.0 QC21 FINAL INSPECTION/W/O RELEASE



06/12/06

20

Comment: FINAL INSPECTION/W/O RELEASE

06/12/06

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

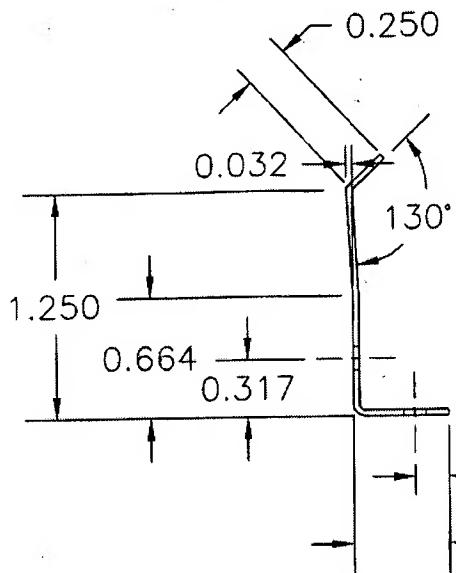
NOTE: Date & initial all entries

DART

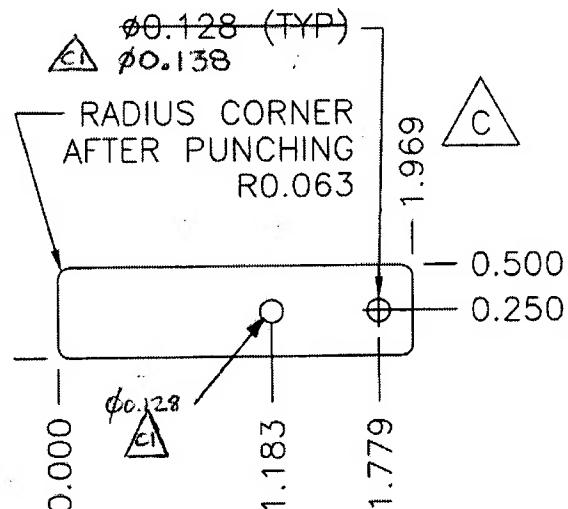
© COPY IS SUB
DRAFT

DESIGN KE	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2429	REV. C SHEET 1 OF 1
DATE 00.06.26		TITLE SPRING CLIP	SCALE 1:1
A	95.07.21	NEW ISSUE	
B	97.10.09	ADDED ASSEMBLY	
C	00.06.26	1.969 WAS 2.100; 0190 WAS 0.321	
C1	01.03.27	Ø 0.138 WAS Ø 0.128	

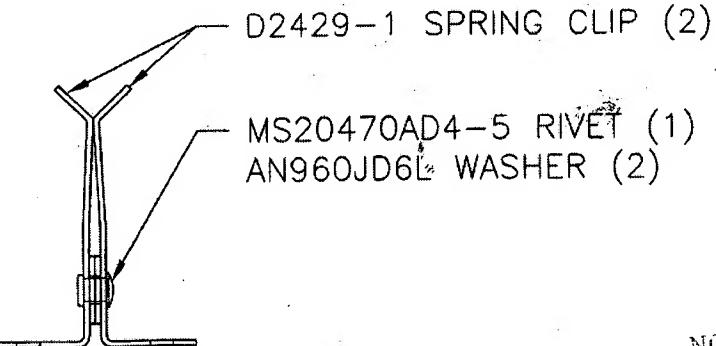
RELEASED
00.06.27 #



D2429-1 SPRING CLIP



D2429-1 FLAT PATTERN



D2429-041 SPRING CLIP ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
29025

MATERIAL: AISI 304/316 SS 0.040 THICK 0.50 WIDE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSION ARE IN INCHES

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DART AEROSPACE LTD		Work Order:
Description:		Part Number:
Inspection Dwg:		Rev:
Page 1 of 1		

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	<u>M. M</u>	Audited by:	<u>J. M</u>	Prototype Approval:	
Date:	06/10/18	Date:	06-10-18 00:00	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	